

GREEN

Date: Thursday, 6/21/2007 2:28:37 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 33041	
Estimate Number : 10531	
P.O. Number : <i>N/A</i>	Part Number : D2572
This Issue : 6/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 32166	Material : <i>N/A</i>
Written By : _____	Due Date : 7/11/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 12 Um: Each
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: *25350*

[Signature] 07/07/10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. *SA* Double check by: *J.F.*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

[Signature] SA 07.07.10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

[Signature] SA 07.07.10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] SA 07.07.10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/07/13

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MA 07-07-16 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3

MPV BR 07-07-16 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/7/17 (12x) 50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/17 50 (12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17

Job Completion



h 07/07/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33041
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		7.998	7.997	8.000	7.999		
F	0.490	0.510		0.500	0.507	0.502	0.503		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.497	0.498	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.567	0.567	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.123	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.257	0.257	0.257		
S	0.115	0.135		0.135	0.131	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.961	2.961		
V	0.230	0.250		0.249	0.240	0.241	0.242		
W	0.115	0.135		0.130	0.132	0.131	0.130		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.358	0.362	0.360	0.363		
AA	0.470	0.530		0.506	0.500	0.500	0.500		
AB	0.615	0.635		0.636	0.630	0.630	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.257	0.248	0.247	0.248		
AE	1.375	1.395		1.383	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.262	0.260	0.260	0.260		
AH	0.240	0.260		0.257	0.251	0.252	0.253		
AI	2.000	2.020		2.000	2.002	2.004	2.003		
AJ	0.023	0.043		0.033	0.037	0.033	0.033		
Accept/Reject									

Measured by:	<i>Jul</i>
Date:	07/07/09

Audited by:	<i>J.L.</i>
Date:	07/07/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>Jul</i>

DART AEROSPACE LTD	Work Order:	33041
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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B	1.745	1.755		1.749	1.749	1.750	1.749		
C	3.495	3.505		3.499	3.506	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.750		
E	7.990	8.010		8.000	7.998	8.001	8.002		
F	0.490	0.510		0.501	0.500	0.499	0.493		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.498	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.568	0.566	0.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.124	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.256	0.251	0.251		
S	0.115	0.135		0.136	0.132	0.132	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.961	2.961	2.961		
V	0.230	0.250		0.240	0.241	0.241	0.241		
W	0.115	0.135		0.126	0.130	0.130	0.129		
X	0.307	0.312		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.766	0.760	0.762	0.762		
Z	0.352	0.372		0.365	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.249	0.248	0.249		
AE	1.375	1.395		1.385	1.385	1.385	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.266	0.266	0.260		
AH	0.240	0.260		0.249	0.251	0.251	0.251		
AI	2.000	2.020		2.001	2.003	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>me/SA</i>
Date:	07.07.10

Audited by:	<i>J.L</i>
Date:	07/07/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SA</i>

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B	1.745	1.755		1.750	1.750	1.751	1.745		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	7.995	8.007		
F	0.490	0.510		.502	.500	.508	.495		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.502	.503	.500	.503		
J	1.174	1.184		1.175	1.175	1.175	1.175		
K	0.558	0.578		.571	.565	.570	.571		
L	1.174	1.184		1.175	1.175	1.177	1.175		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.495	2.499	2.498		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.124	.124		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.252	.251		
S	0.115	0.135		.130	.131	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.961		
V	0.230	0.250		.242	.243	.241	.243		
W	0.115	0.135		.125	.125	.129	.125		
X	0.307	0.312		.311	.310	.311	.311		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.355	.362	.363	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.257	.252	.257	.257		
AE	1.375	1.395		1.386	1.385	1.386	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.252	.254	.251	.251		
AI	2.000	2.020		2.002	2.007	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

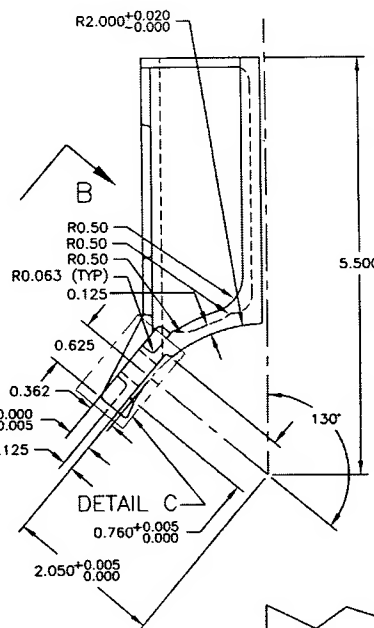
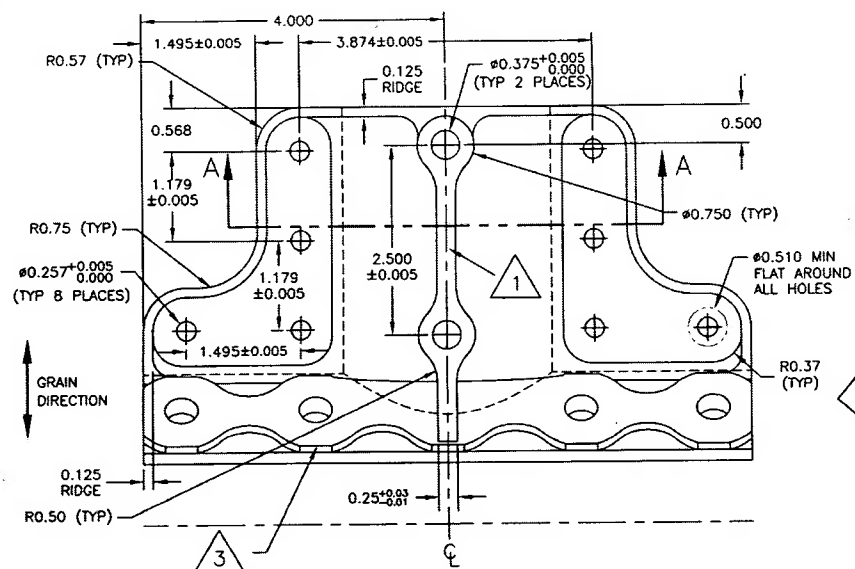
.312
.439
2.124

Measured by:	SA
Date:	07/07/10

Audited by:	J.L
Date:	07/07/13

Rev	Date	Change	Revised by	Approved
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

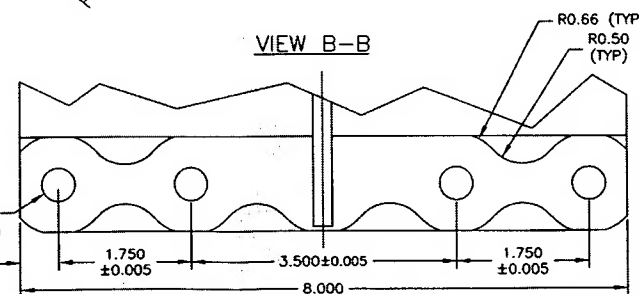
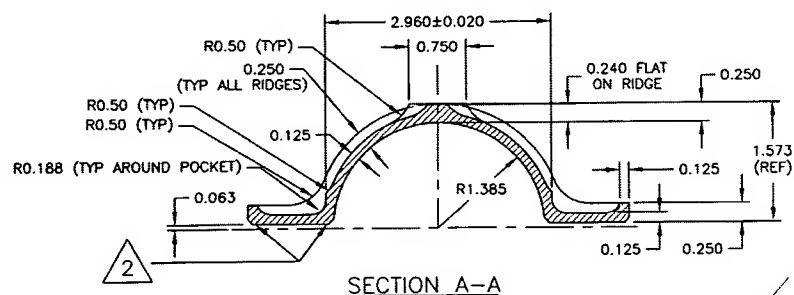
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2572	REV. SHEET 1 OF
DATE 05.07.13	TITLE INNER FWD SADDLE		SCALE 2:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3304 1